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Application No.: 10/002560

Case No.: 56911US002

Amendments to the Specification:

Please replace the paragraph at page 2 lines 18-30 with the following:

Figure 1a shows a conventional calendering process for capping stem webs. In figure 1a, the stem web 10, having a backing 12 and stems 14 thereon, is maneuvered over idler 16 and directed into a nip 26 between heated roll 20 and cooled roll 24. The stem web 10 is then directed through a second nip 28 between cooled roll 24 and heated roll 30. The stem web 10 then passes through a third nip 32 between heated roll 30 and cooled roll 34, and then a fourth nip 36 between cooled roll 34 and heated roll 38. The stem ~~when web~~ 10 is then directed to a fifth nip 40 between heated roll 38 and cooled roll 42. ~~At last, the~~ ~~The~~ stem web 10 is ~~then~~ directed to a sixth nip 44 between cooled roll 42 and heated roll 46. ~~At last~~ Finally, the fully capped web 48 is then drawn off. It should be noted that because heated roll 20 at the top and heated roll 46 on the bottom are loaded on only one side, they have a larger diameter to minimize deflection. This process has been successfully used to fabricate HookIt II brand abrasive sanding disks commercially available from Minnesota Mining & Manufacturing Co. of St. Paul, Minnesota.